

Date: Tuesday, 12/5/2006 7:51:37 AM
 User: Kim Johnston

Process Sheet

SPLIT-2.

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29739
 Estimate Number : 11795
 P.O. Number : NIA
 This Issue : 12/5/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : LARGE FAB ASSY
 Previous Run : NIA
 Drawing Name : 407 STEP ASSEMBLY
 Part Number : D206628033
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material : NIA
 Due Date : 1/20/2007 Qty: $\frac{3}{4}$ Um: Each
 Written By : JOE 12 05
 Checked & Approved By : JOE 12 05
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy blue file and type labels as per PPP D206-628-033 CHG 002

KS 06.12.11 (3)

2.0 29739A FLOAT STEP ASSEMBLY LH (206/407)



Comment: Sub-Component SUB-ASSEMBLY
 206B STEP ASSY, LH
 D2842-041 B 29739A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0 D27313 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
4	D2731-3	Mounting Lug	B27420

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2844-1	Arm	B11188

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 29739

Part Number: D206628033

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 D28443 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2844-3 Arm B25786 - ✓

7.0 D2856400 Abrasion Strip



Comment: Qty.: 1.2605 f(s)/Unit Total: 5.0421 f(s)

Pick:

Qty Part # Description Batch
2 D2856-400 6.25" Abrasion Strip B26650 B29810 - ✓

8.0 D3394041 LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D3394-041 LUG ASS'Y B25711 5X 7 X 29794 6/7/20 ✓

9.0 AN3C4A BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3C4A Bolt M101390 - ✓

10.0 AN4C12A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4C12A Bolt M19600 2X M102759 24X - ✓
M102757 M103481 6X - ✓

11.0 AN4C15A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4C15A Bolt M100447 - ✓

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 29739

Part Number: D206628033

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 AN960C10 WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number Description Batch

3 AN960C10 WASHER

M101064 -

13.0 AN960JD416L Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960JD416L Washer

M101237 -

14.0 NAS1515H4L Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

M102985 - 96X

15.0 MS210434 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4 Nut (or MS21042-4)

M181350. 4X M102038 44X -

16.0 NAS1515H3 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

M102983 -

10/12/04 (4)

17.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/07/02/14 (4)

Date: Tuesday, 12/5/2006 7:51:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 29739

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-033

Location: _____

PPP Rev: C

P-7/2/14 (1)

(1 HAI)

P-7/2/21 (2)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/22

Job Completion





U 07-07-22

Dart Aerospace Ltd.

Date: Tuesday, 12/5/2006 7:52:06 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29739A
Estimate Number : 11664
P.O. Number : N/A
This Issue : 12/5/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 26752A
Written By : 
Checked & Approved By : 
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Drawing Name	: FLOAT STEP ASSEMBLY LH (206/407)			
Part Number	: D2842041			
Drawing Number	: D2842 REV B			
Project Number	: N/A			
Drawing Revision	: B			
Material	: <i>PLA</i>			
Due Date	: 1/20/2007	Qty:	4	Urn: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
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1 D2622-120C Extrusion 329607

Check Material for any Dents or Defects

PL. 07.02.02 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
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2 D2734 End Cap

Batch
329340

07.02.06 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29739A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3 Lug 329195 = 4 330668 = 4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug 327121

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R AL Rod Batch: m100237
m102225

2-Grind end cap weld flush

LE. 07.02.07 4

LE. 07.02.07 4

7.0

QC5/9

WELD INSPECTION



07/02/08 (4)



Comment: WELD INSPECTION

John 08/04

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/14

07-02-08 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LE. 07.02.12 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29739A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M100237

2-Grind end cap weld flush.

Handwritten: J.E. 07.02.12 4
J.E. 07.02.12 4

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 07/02/12 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 07/02/12 (4)

13.0

POWDER COATING

POWDER COATING



Handwritten: Alodine VPS/

Handwritten: YP

Handwritten: M103141

Handwritten: FX/



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: 07-02-12 (4)
07/02/12 (4)

14.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3

NAS1329C3KB130Insert

Handwritten: M100034 (5X) (7X) M102774

Handwritten: (4)

15.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

Handwritten: M19522
M18052

Handwritten: a.m 07/02/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: H Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 7:52:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 29739A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

n 102724

17.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 AN960C10L

WASHER

M 103344

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: *102098*

yl 07/02/13 x4

19.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1 for HAI

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/14

Job Completion



07/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

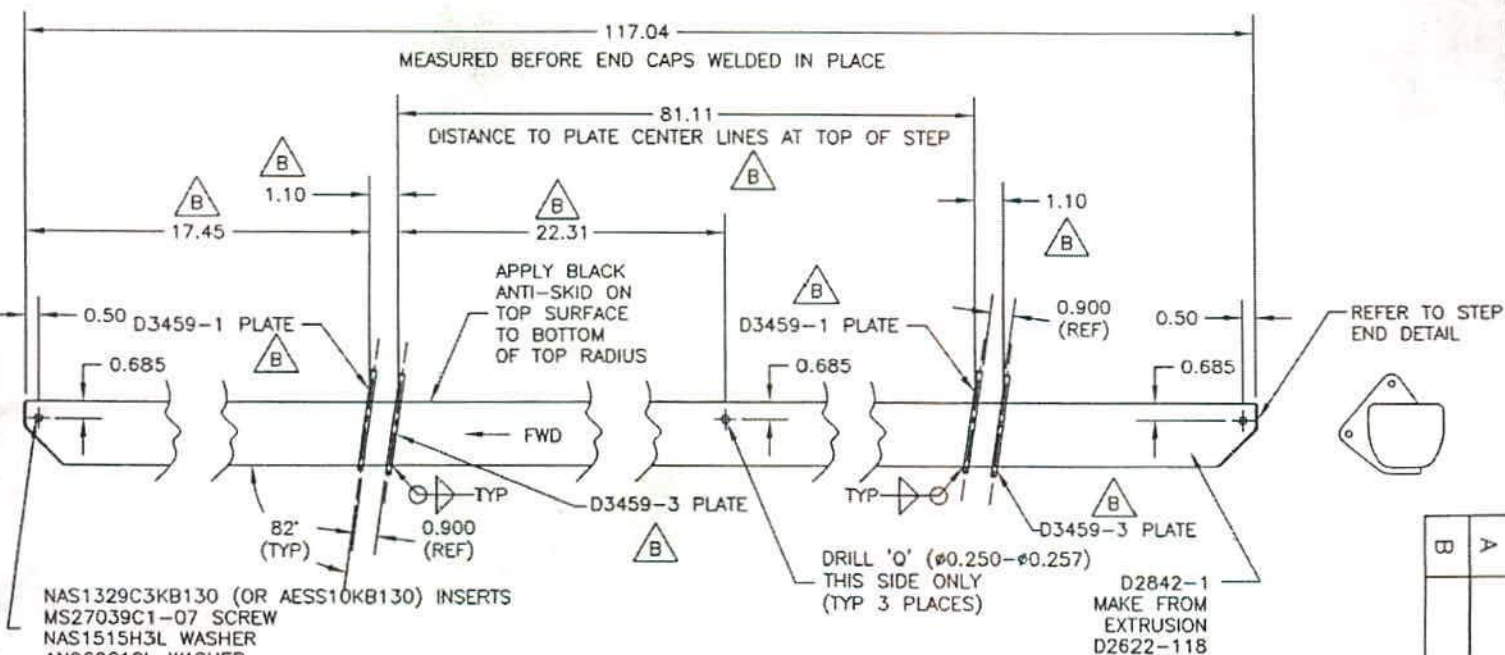
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	D2842
05.09.23	98.10.13	206L/407 FLOAT STEP ASSEMBLY
	05.09.23	NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE
		NTS
		REV. B
		SHEET 1 OF 1



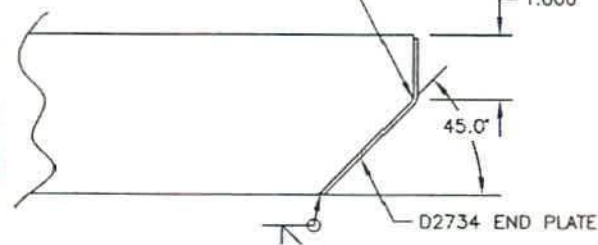
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05-11-14